

Work Order ID 54203



December 2, 2009 3:28:03 PM

W/O:
Dart Aerospace Ltd

Item ID: D205-634-041
Revision ID: D
Item Name: Replacement Skidtube

Accept



Setup Start

Stop



Start Date: 03/12/2009 Start Qty: 1.00

Required Date: 17/12/2009 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

RP

Date:

07-12-2

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2580	Rev D

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

*N/A pulled in
w/ 51231*

110

0.00



CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

0.00

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

1 249/12/9

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54203



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December 2, 2009 3:28:04 PM

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

1 49/12/9

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 50/12/09



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod *m112860**BE 09/12/10*

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod *m112860**BE 09/12/10*

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Debur holes

6-Drill pilot holes for aff cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Towing using DT8091, open to .640" and Debur

AWM 9-12-10

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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	27 S on 12/10						
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	27 S on 12/10						
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00	PR 09-12-11						

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M/12148.</i> Memo START TIME: <u>9:00</u> OVEN TEMPERATURE: <u>350°</u> FINISH TIME: <u>9:30</u>	0.00 0.00	<i>6/09-10-11</i>			<i>①</i>			
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>M/ 09/12/14</i>			<i>(X1)</i>	<i>②</i>		

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M1112345
Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M1112345
Sikaflex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: M1112363

⇒ M 02/12/14 (X1) Ø

Dart Aerospace Ltd

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



275 09/12/14

QC

Memo

0.00



Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

PPPSI231

09/12/2014

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/24

09/11/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

December 2, 2009 3:28:10 PM

Work Order ID: 54203



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 03/12/2009

Required Date: 17/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD		Manufactured	No			110	Each	4.0000	1.0000			

205 Skidtube bent detail

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

53539

53540

BS4121 D

4

2

2

119/12/09

D2576-3RevG

Manufactured No



Step (maching detail)

140

Each

159.0000

1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

43504

46661

52215

159

11

101

47

25370

*

1

BE 09/12/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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December 2, 2009 3:28:10 PM

Work Order ID: 54203

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube



Comments:

Start Date: 03/12/2009

Required Date: 17/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE		Manufactured	No			140	Each	135.0000	20.0000			
												
Crossbolt Spacer												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse	B 53780	x20
LG	13	
51525	13	
Main Warehouse		
ST	122	
43988	4	
46434	4	
46956	2	
47797	9	
48272	2	
51314	71	
51315	30	

BE 09/12/10

D2855RevA

Manufactured No

200

Each

58.0000

1.0000



Cap

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP6	58	
50513	1	
50770	3	
51539	54	

x1 09/12/10

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube


Start Date: 03/12/2009

Required Date: 17/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A  Bolt		Purchased	No			200	Each	2,043.000	2.0000			

Warehouse
Location
Main Warehouse
ST

Loc Qty

Loc Code

100188

188

105057

1855

x2 21 09/12/14

AN960JD10L

Purchased

No

200

Each

5,443.000 2.0000

Washer

Warehouse
Location
Main Warehouse
ST

Loc Qty

Loc Code

101291

16

104885

153

105793

236

09632

280

110985

4758

x2 21 09/12/14

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December 2, 2009 3:28:10 PM

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Comments:

Start Date: 03/12/2009

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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Pin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

ALS7-1032-130		Purchased	No			200	Each	2,748.000	50.0000			
---------------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



Insert

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	2748	
105855	16	
108606	52	
11529	1356	
111779	313	
112772	11	
113238	1000	

X50 28 09/12/11

AN3C4A		Purchased	No			200	Each	1,247.000	50.0000			
--------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



BOLT

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	1247	
112314	13	
112720	12	
112724	3	
112829	1	
112991	2	
113121	216	
113226	1000	

M113359

X50 28 09/12/11

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L washer		Purchased	No			200	Each	1,682.000	50.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	1582	
112116	512	
112612	342	
112933	728	

x50 91 09/12/14

D3566-13RevC

Manufactured No



Gasket

200 Each 106.0000 1.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	104	
51606	21	
53461	83	
Main Warehouse		
ST	2	
45717	1	
50265	1	

x1 91 09/12/14

W/O:		WORK ORDER CHANGES					
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D3566-5RevC		Manufactured	No			200	Each	31.0000	1.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	26	
(53804)	26	
Main Warehouse		
FP19	1	
52909	1	
Main Warehouse		
ST	4	
36113	1	
46186	1	
47318	1	
51260	1	

214/09/12/14

W/O:		WORK ORDER CHANGES					
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D3566-1RevC		Manufactured	No			200	Each	31.0000	2.0000			
Gasket												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	26	
52512	3	
53790	23	
Main Warehouse		
ST	5	
46349	1	
51218	1	
51259	3	

87 12/09/12/14

D3564-11RevD

Manufactured No

200

Each

28.0000

1.0000

Wearshoe

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP19	26	
52125	14	
53808	12	
Main Warehouse		
ST	2	
45823	1	
50112	1	

B53808

11 11/09/12/14

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Shop Packet Print

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 2, 2009 3:28:10 PM

Page 8 / 10

Work Order ID: 54203



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 03/12/2009

Required Date: 17/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-13RevD		Manufactured	No			200	Each	46.0000	1.0000			

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP17	34	
51611	32	
52059	2	
Main Warehouse		
ST	12	
45409	2	
46495	10	

XC 24 09/12/14

D3564-9RevD

Manufactured No

200

Each

4.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP19	2	
52593	2	
Main Warehouse		
ST	2	
44659	1	
45825	1	

1353806

XC 24 09/12/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 2, 2009 3:28:10 PM

Page 9 / 10

Work Order ID: 54203

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 03/12/2009

Required Date: 17/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-5RevD		Manufactured	No			200	Each	29.0000	1.0000			

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
34806	2	
Main Warehouse		
FP19	23	
51925	1	
53805	22	
Main Warehouse		
ST	4	
45824	1	
47433	1	
52595	2	

x1 Jpl 03/12/14

D2594-3RevC

Manufactured No



O-Ring, 205 Skidtube

200 Each 602.0000 16.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	27	
51613	27	
Main Warehouse		
ST	575	
52562	575	

x10 Jpl 03/12/14

December 2, 2009 3:28:10 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 10 / 10

December 2, 2009 3:28:10 PM

Work Order ID: 54203



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 03/12/2009

Required Date: 17/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-1RevC		Manufactured	No			200	Each	314.0000	16.0000			

Plug, 205 Skidtube

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	121	
<u>54008</u>	121	
Main Warehouse		
ST	193	
42221	16	
42807	92	
43884	3	
46435	2	
51527	9	
51757	71	

116 W 02/12/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 54203
BP 09-12-2

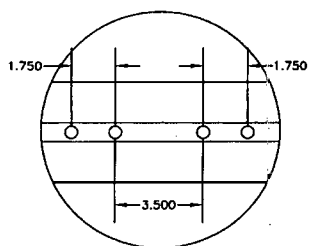
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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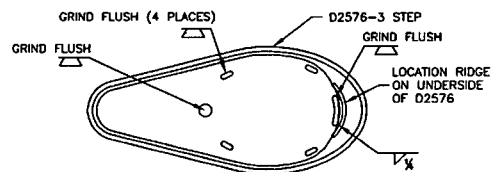
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DETAIL A
SCALE 5:24

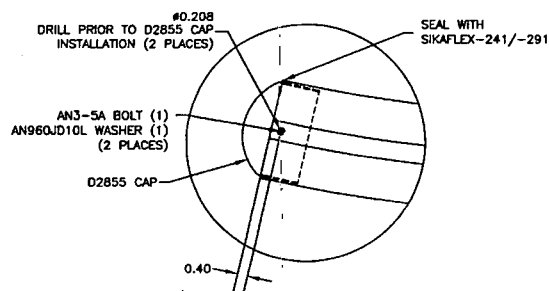


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07.02.27

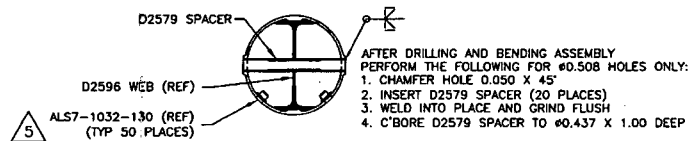
DETAIL B
SCALE 5:24



DETAIL C
SCALE 5:24



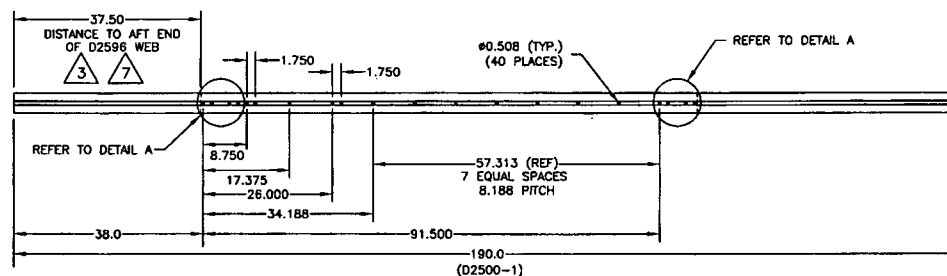
SECTION D-D
SCALE 5:24



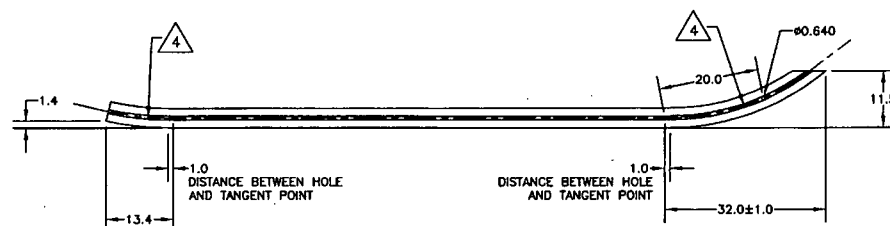
D2580-041 NOTES

- 1) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

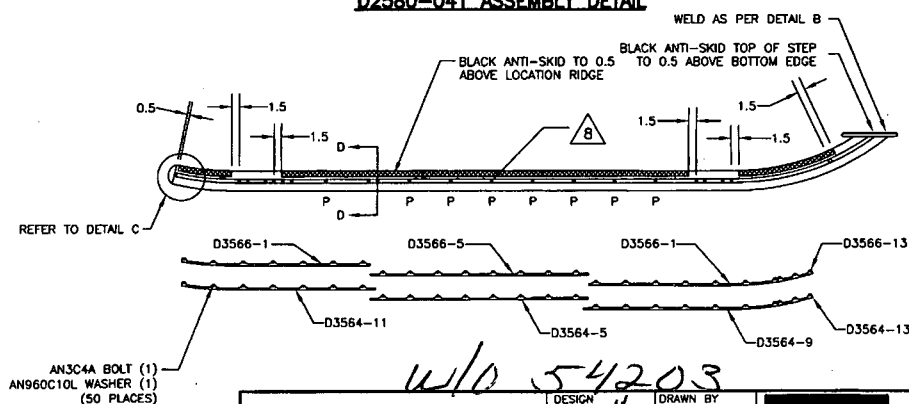
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL

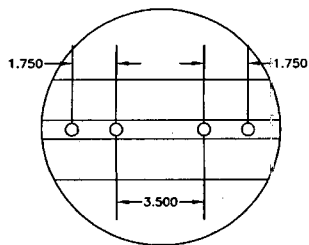


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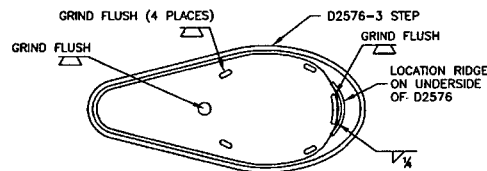
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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2580	REV. 0 SHEET 2 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24

DETAIL E
SCALE 5:24

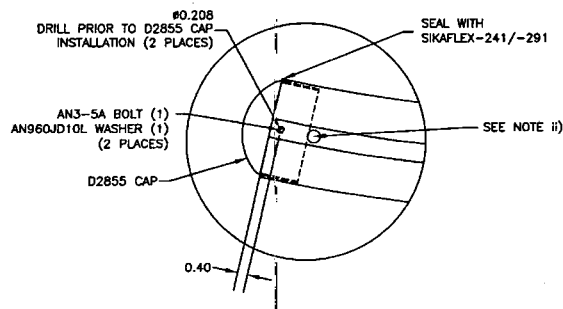


DETAIL F
SCALE 5:24

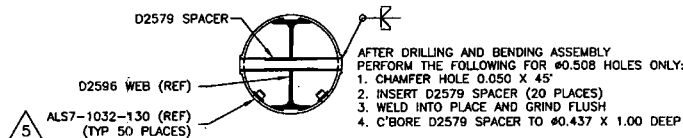


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07.02.27

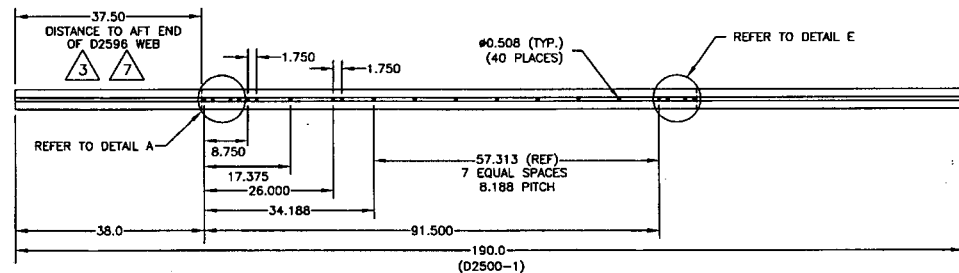
DETAIL G
SCALE 5:24



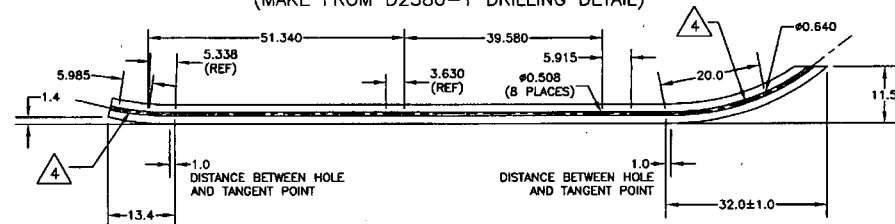
SECTION H-H
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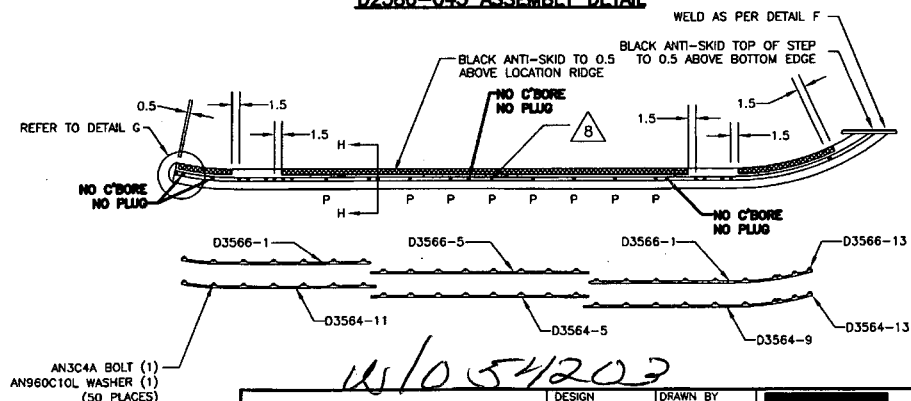
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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CHECKED <i>RH</i>	APPROVED <i>RH</i>	DRAWING NO. D2580	REV. 0
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SHEET 3 OF 3	SCALE 1:24

NO. 219

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Bardley Elliott
Job number: 53910
Part number: D205-634-041
Description: 205 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Dwyer Date of Test Coupon 09.12.04
Welder Bardley Elliott Date of Test Coupon 09.12.04

The above named individual is qualified in accordance with AWS D17.1.2001 to weld